

Work Order ID 60197

Monday, June 28, 2010 3:20:16 PM



Page 1

Item ID: D2282-043

Accept



Setup

Start



Revision ID:

Stop



Item Name: Saddle Assembly

Start Date: 6/28/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: *RL*

Date: *10-6-29* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly
A/RER316L SS Filling Rod *10107051*
Dwg Rev: *E*

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***
2 -Tumble

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

CP 10-07-14

CP 10-07-14

10-7-21

(40) 10.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2282-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle Assembly

Start Date: 6/28/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 40.00

Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				counted (x40)			
160  Packaging Packaging	Identify as per dwg & Stock Location: 262 Memo	0.00 0.00				15.7	22	4025	
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/07/23 MF 10-7-22

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Picklist Print

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Page 1

Work Order ID: 60197

Parent Item: D2282-043

Parent Item Name: Saddle Assembly



Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2281  Jack Saddle		Manufactured	No			100	Each	57.0000	1	40			
<div> <div>Location</div> <div>ST261</div> <div>57518</div> <div>59804</div> </div> <div> <div>Loc Qty</div> <div>57</div> <div>210</div> <div>49</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D2282-7  Tube		Manufactured	No			100	Each	24.0000	2	80			
<div> <div>Location</div> <div>WA</div> <div>48283</div> <div>56690</div> <div>58432</div> </div> <div> <div>Loc Qty</div> <div>24</div> <div>1</div> <div>22</div> </div> <div> <div>Loc Code</div> <div></div> </div>													

B59803 → (57) Pl 10.07.13

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

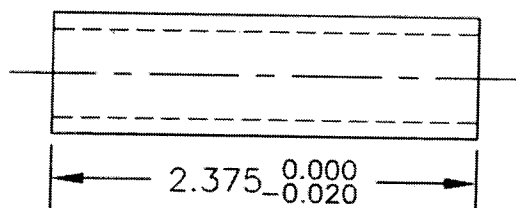
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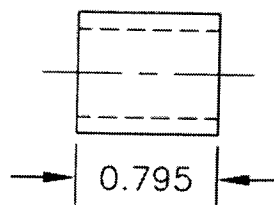
NOTE: Date & initial all entries



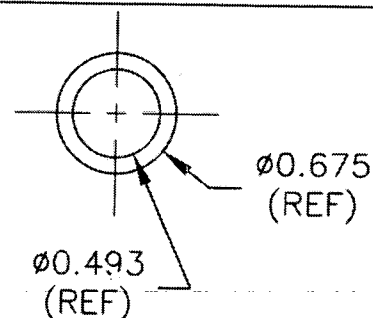
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3

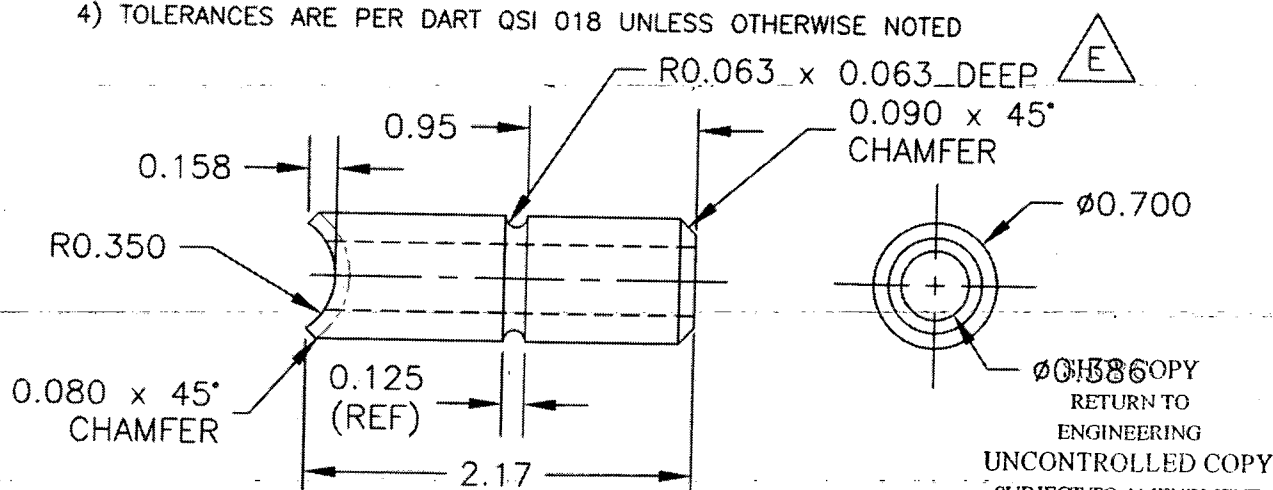


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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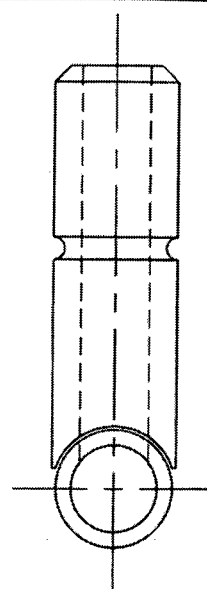
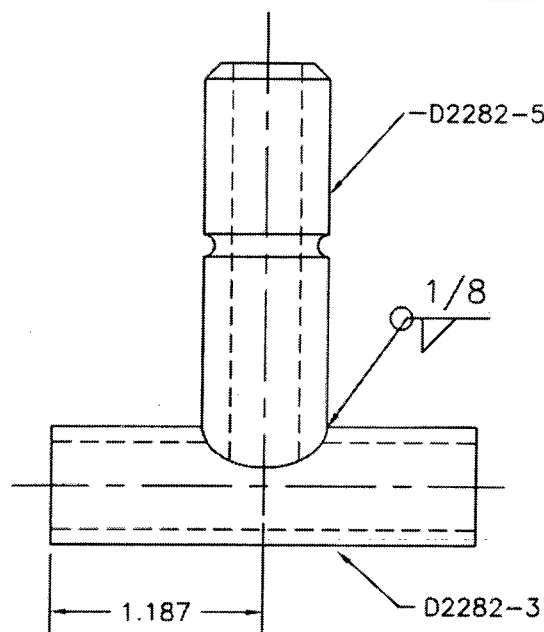
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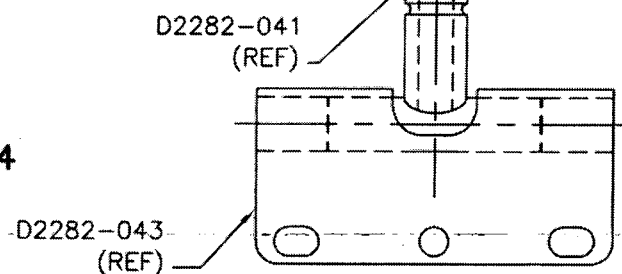


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

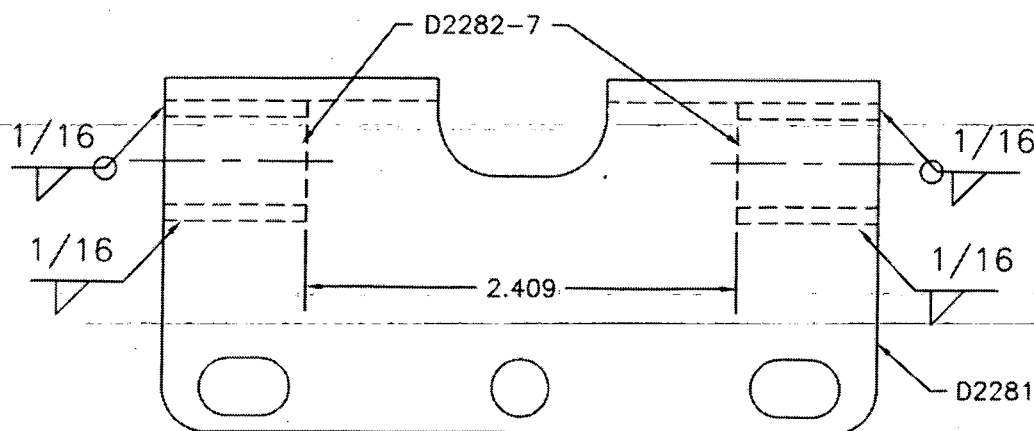


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

w/o 60197

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